

Date: Tuesday, 28/10/2008 3:40:58 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FLOOR WINDOW
Job Number	: 43034		
Estimate Number	: 10457		
P.O. Number	:	Part Number	: D32121
This Issue	: 28/10/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3212 REV B
First Issue	: / /	Project Number	: N/A
Previous Run	: 42411	Drawing Revision	: B
	Type : SMALL /MED FAB	Material	: Multiples of 4
Written By	:	Due Date	: 05/11/2008
Checked & Approved By	: <u>JLD 08.10.09</u>	Qty:	12 Um: Each
Comment	Est Rev: A New Issue 05-11-09 JLM Est Rev: B Water jet/ ecn798 06-05-08 EC est rev.C back on haas 07.04.09 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MACRLICS125	1/8" Polycast II Sheet
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Comment: Qty.: 1.0232 sf(s)/Unit Total: 12.2787 sf(s)
 Material: 0.125" Polycast Sheet
 (M-ACRYLIC-S.125)
 Identify as D3212-1
 Batch: 109570 B 8-11-6
B 8-11-3

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut blankas per Dwg D3212 B 8-11-6
 Dwg Rev: B B 8-11-3
 Prog Rev: B

2-Deburr if necessary

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: Machine as per Folio FA349 and Dwg D3212

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: D3212-1 PAR #: N/A Fault Category: Prod / Med & Small NCR: Yes No DQA: D Date: 08/12/12
 Resolution: PROCESS raised Disposition: SCRAP QA: N/C Closed: D Date: 08/12/12

NCR: 43034		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/11/14	# 2-C	all 12 parts scrap due to blow outs from water jet around the holes.	[Signature]	Scrap and Destroy Qty (N2)	[Signature]	08-11-05	[Signature]	08/11/04
		R.C only Blanks to be cut on water Jet Revised the heat to be Done on HANS.		cut Blanks only for Replacement and machine in HANS. Qty 612	[Signature]	08-11-05		
		<u>Process Deviated</u>	[Signature]	3# 109530	[Signature]	08/12/15	[Signature]	08/11/04
				Remove Program on water Jet to cut corner and holes.	[Signature]			

NOTE: Date & initial all entries

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Drawing Name: FLOOR WINDOW

Job Number: 43034

Part Number: D32121

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 08/12/15

(30)

6.0

D27281

Dart Logo Label - small



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

Qty Part # Description Batch

1 D2728-1 Dart Logo label B39012

* can't pull

SAD 08/12/15

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr if necessary

2-Install label as per Dwg D3212

3- polish abrasion scratches if necessary..

4-Wrap in plastic wrap after inspection

SAD 08-12-15 3*

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

* think that parts should be ordered

SAD 08/12/15 counter (422)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 210

6/12/15

SC

(30+)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/12/15

Job Completion



MF 08-12-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: <u>H3034</u>
Description: Floor Window		Part Number: D3212-1
Inspection Dwg: D3212	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
12.734	+/-0.005	12.734	✓			
6.367	+/-0.005	6.366	✓			
0.625	+/-0.005	.625	✓			
Ø0.156	+0.005/-0.001	.150	✗			
R0.25	+/-0.030	.25	✓			
8.150	+/-0.005	8.147	✓			
3.750	+/-0.005	3.753	✓			
0.313	+/-0.010	.313	✓			
15.14	+/-0.030	15.125	✓			
12.520	+/-0.005	12.520	✓			
6.260	+/-0.005	6.264	✗			
1.312	+/-0.005	1.313	✓			
0.313	+/-0.010	.312	✓			
3.750	+/-0.005	3.746	✓			
8.150	+/-0.005	8.154	✗			
8.462	+/-0.005	8.466	✗			
9.09	+/-0.030	9.085	✗			

Measured by: <u>B / JLM</u>	Audited by: <u>J.F.</u>	Prototype Approval:	N/A
Date: <u>08/12/13</u>	Date: <u>08/12/15</u>	Date:	N/A

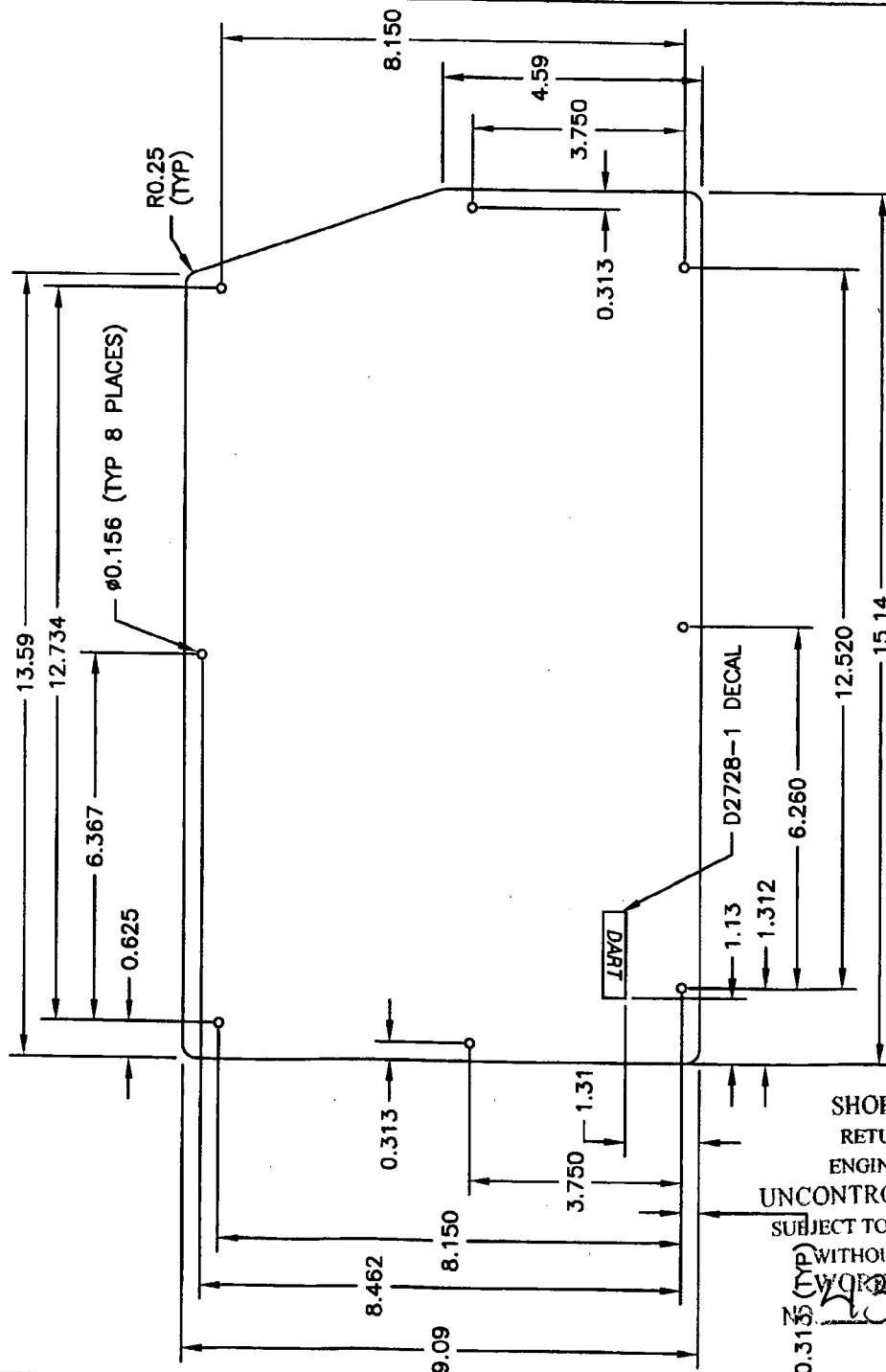
Rev	Date	Change	Revised by	Approved
A	03.12.15	New Issue P/O D350-567-015/-025/-031	KJ/RF	
B	07.05.28	Dimensions updated per Dwg Rev. B	KJ/JLM	

DART

DESIGN	CP	DRAWN BY	SSH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	REV. B
DATE				D3212	SHEET 1 OF 1
06.04.13				TITLE	SCALE
				FLOOR WINDOW	1:3
A	03.09.03	NEW ISSUE			
B	06.04.13	UPDATE MATERIAL PER NCR 029			

D3212-1 FLOOR WINDOW

- 1) CHECK DIMENSIONS WITH TEMPLATE D3212-1T1
- 2) DIMENSIONS ARE IN INCHES AND ARE FOR REFERENCE ONLY
- 3) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK (REF. DART SPEC. M-ACRYLIC-S.125)
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



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0.313 (TYP)
43034

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